

Work Order ID 55199

January 11, 2010 1:07:40 PM



ASAP

Page 1

Item ID: D3622-1

Accept



Setup Start



Revision ID:

Item Name: Ball Stud

40

Stop



Start Date: 1/11/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 1/18/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-01-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3622

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA686 & DWG D3622 ,

FOLIO REV: B

DWG REV: B

2-DEBURR AS REQUIRED

10/01/12
SA

40

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10/01/12

40

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10/01/12

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55199

January 11, 2010 1:07:40 PM

Page 2

Item ID: D3622-1

Accept

Revision ID:

Item Name: Ball Stud

Start Date: 1/11/2010 Start Qty: 20.00

Required Date: 1/18/2010 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 75

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

10/01/13 (40)

10/01/14
mr 10-1-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55199



Parent Item: D3622-1



Parent Item Name: Ball Stud

Start Date: 1/11/2010

Required Date: 1/18/2010

Comments: IPP Rev:A New Issue 07-04-24 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No			100	f	145.8320	2.2737			
303 HEX BAR .500												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	145.832	
109778	120.812	
109846	25.02	

4.4 10/01/12
 5107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

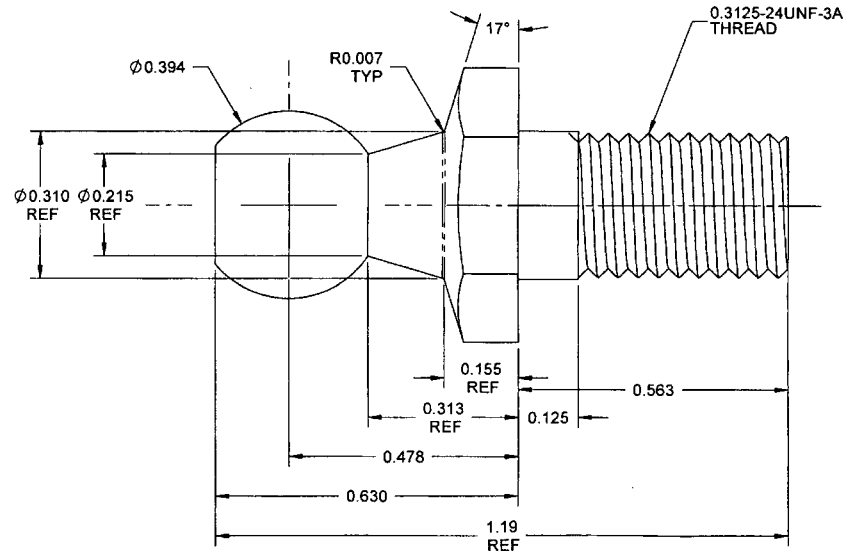
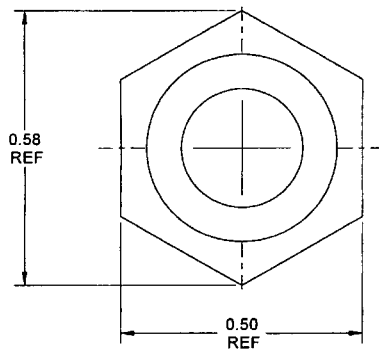
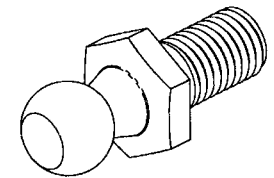
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

210
362

#55199



RELEASED
2009-10-08
MB

D3622-1 BALL STUD

- NOTES:
- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3622-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.03 lbs

B	ADD -3 (SHEET 2)	MB	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION		DATE
DESIGN	B	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.S.S	DRAWING NO.	REV. B
MFG. APPR.	21	D3622	SHEET 1 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	MB	BALL STUD	NTS
DATE	09.09.18	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

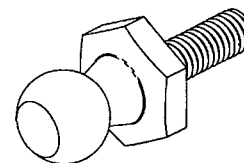
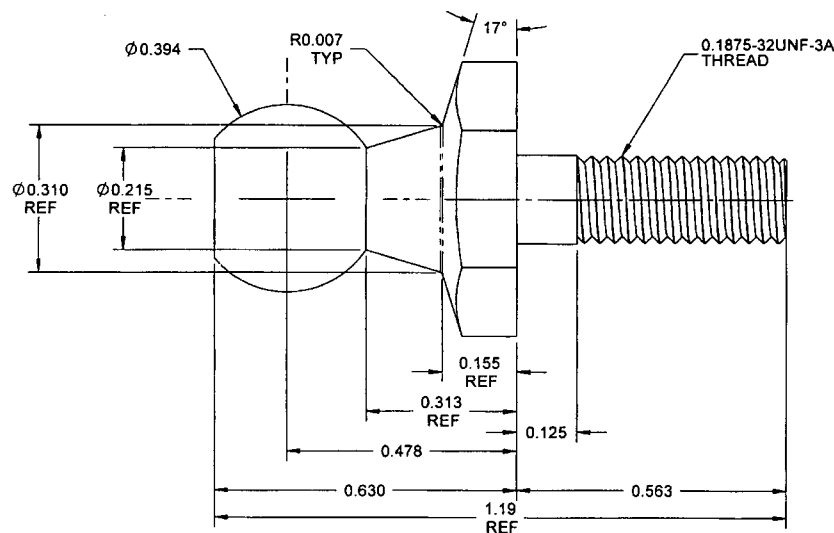
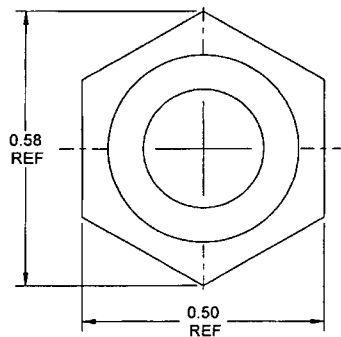
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries








#55199

D3622-3 BALL STUD

RELEASED
2009-10-08
M

- NOTES:**
- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3622-3" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. B
MFG. APPR.		D3622	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BALL STUD	NTS
DATE	09.09.18	COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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